

Work Order ID 55106

January 06, 2010 11:14:25 AM



Page 1

Item ID: D120-638-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 1/6/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 1/20/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 10-01-06 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2435

Rev E1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D120-638-011 CHG 002

506120

for BG 10/01/20

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-1-20 10 S2

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

506120

XC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Run Start

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD120-638-011

Location: _____

0.00

0.00

REUA

10-1-20

10 SP

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/01/20

MF

10-1-20

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Picklist Print

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Work Order ID: 55106

Parent Item: D120-638-011

Parent Item Name: Bearpaw

Comments:

Start Date: 1/6/2010

Required Date: 1/20/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2435



Bearpaw, 206

Manufactured

No

160

Each

4.0000

2.0000



B54901 10-1-20 sl

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

53431

4

D2182B050



Clamp Cushion Black

D2274



Radius Block

Manufactured

No

160

Each

0.0000

4.0000



10-1-20 sl 54649

Manufactured

No

160

Each

41.0000

8.0000



10-1-20 SD

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

41

52644

41

D2438



Clamp

Manufactured

No

160

Each

84.0000

4.0000



10-1-20 RD 50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

84

46113

5

53221

79

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 55106

Parent Item: D120-638-011

Parent Item Name: Bearpaw

Comments:

Start Date: 1/6/2010

Required Date: 1/20/2010

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2529		Manufactured	No			160	Each	746.0000	8.0000			
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Washer

10-1-20 sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

746

52745

746

Purchased

No

160

Each

456.0000

8.0000



M113595 10-1-20 sl

AN4-15A



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

456

113121

56

113538

400

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Bearpaw


Comments:

Start Date: 1/6/2010

Required Date: 1/20/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416		Purchased	No			160	Each	1,489.000	8.0000			
											10-1-20	SL
Washer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1489
103691	20
104215	6
108161	329
110523	340
111279	101
111916	482
112314	211
16941	0

MS21042L4

Purchased

No

160

Each

4,077.000

8.0000

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST	4077
102552	6
104248	6
110507	184
111827	2881
113422	1000
15924	0

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Shop Packet Print

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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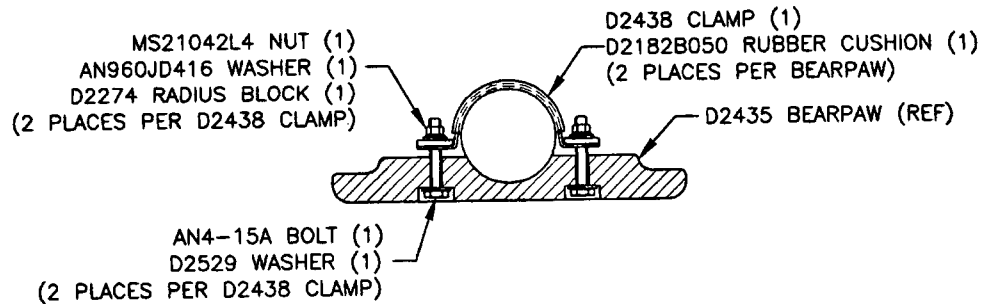


Figure 2 – Bearpaw Installation

4. WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D120-638-011 Bearpaw	8.4 lb 3.82 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	178.7 in 4.54 m	1501.1 in-lb 17.34 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D120-638-011	BEARPAW INSTALLATION
4	D2182B050	Rubber Cushion
8	D2274	Radius Block
8	D2529	Washer
2	D2435	Bearpaw
4	D2438	Clamp
8	AN4-15A	Bolt
8	AN960JD416	Washers
8	MS21042L4	Nut (or MS21042-4)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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